

Date: Wednesday, 5/23/2007 3:43:25 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LATCH ASSEMBLY		
Job Number	: 32504					
Estimate Number	: 10303					
P.O. Number	: N/A		Part Number	: D2586		
This Issue	: 5/23/2007 S.O. No. : N/A		Drawing Number	: D2586 REVD		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: D		
Previous Run	: 30880		Material	: N/A		
Written By	: <i>[Signature]</i>		Due Date	: 6/4/2007 Qty: 100 Um: Each		
Checked & Approved By	: <i>DD 7/05/24</i>					
Comment	: Est E 02.01.31 Added Inspect level 21 NG					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 3831*C207/05/25*

Possible Supplier: Southco, P/N: C2-32-25

Certification Required

*100*

2.0	C23225	DOOR LATCH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

DOOR LATCH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

1-Receive and inspect for transit damage

2-Attach certification

3-Stock Keys as: C2-32-25 Keys

4-Discard hardware

*EJ 07/06/07 (co)* *PLC*

4.0	D30157	Lock Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Lock Nut

Pick:

Qty	Part Number	Description	Batch
1	D3015-7	Lock Nut	<i>B30915</i>

*FF 07-06-28* *100*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/08	3.0	Add a QC5, perm. Change QC5		07/06/08		07/06/08	07/06/08

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/06/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:43:25 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH ASSEMBLY

Job Number: 32504

Part Number: D2586

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Hole to 0.191"

FF 07-06-12

100

2-Counterface as per Dwg D2586

PF 07-06-27

100

3-Assemble Lock Nut to Hinge. Leave Latch Unlocked.

FF 07-06-28

100

6.0 QC5

INSPECT WORK TO CURRENT STEP



DSP 15

En-0266128

cont 81

+ 100

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

P 07/6/28 (100)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



100

Comment: FINAL INSPECTION/W/O RELEASE

07/06/29

Job Completion



07-06-29

54  
30  
16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

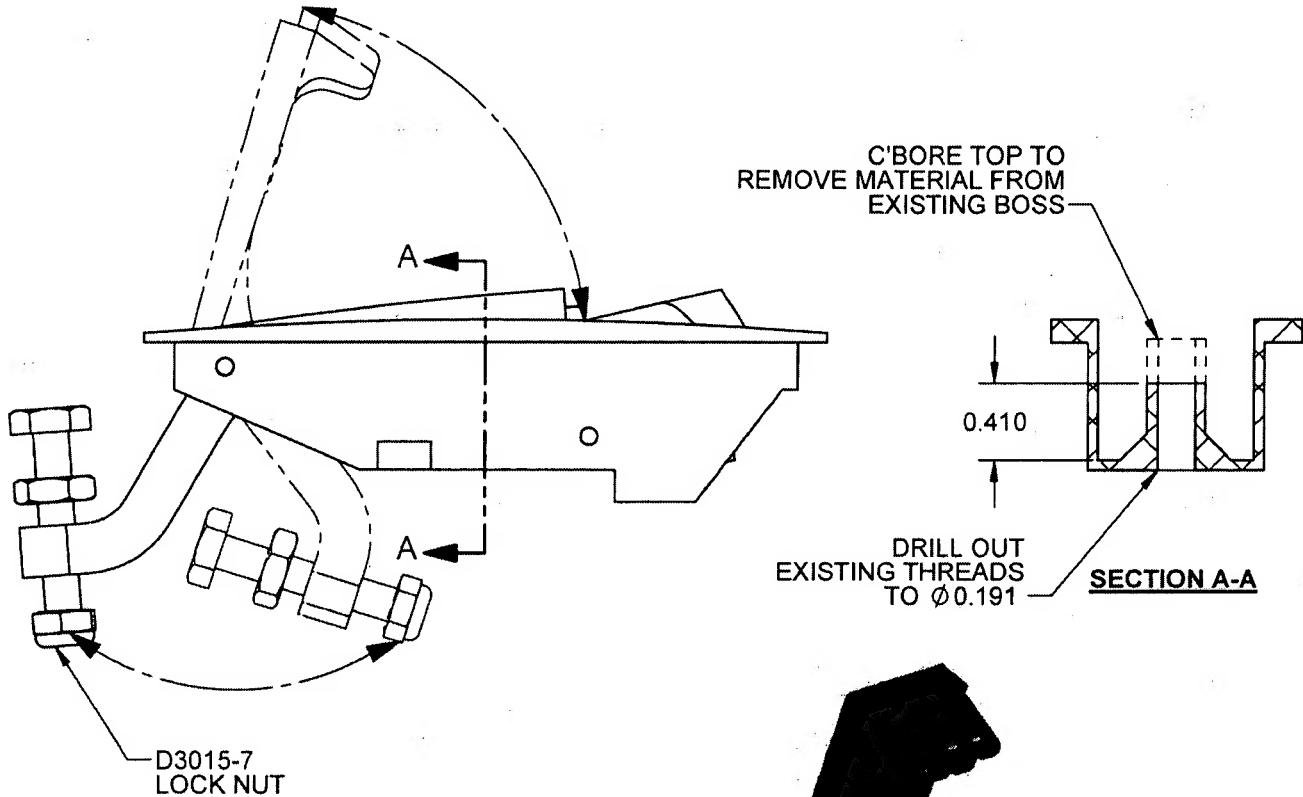
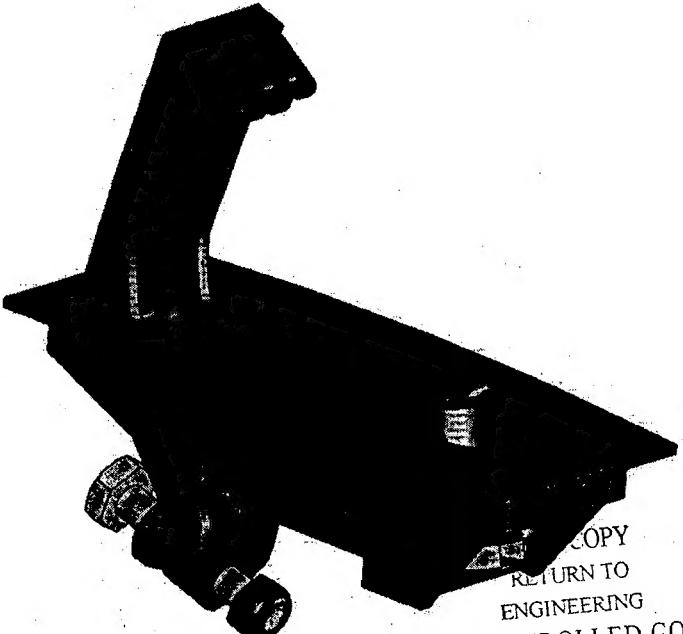
NOTE: Date & initial all entries

**DART**

DESIGN <b>KE</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. <b>D2586</b>
DATE <b>06.10.19</b>		REV. D SHEET 1 OF 1 TITLE <b>DOOR LATCH</b> SCALE 1:1

**RELEASED**  
*06.12.22*

REV	DATE	DESCRIPTION
A	96.07.15	NEW ISSUE
B	97.07.23	CHANGED C'BORE DEPTH
C	97.09.03	REVISED C'BORE DEPTH
D	06.10.19	ADD D3015-7 P/N; UPDATE DRAWING

**D2586 DOOR LATCH****NOTES:**

- 1) MAKE FROM SOUTHCOP P/N: C2-32-25
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS  
OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *32504*

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J.C.H. Sales Inc.

Emblem Crt  
Toronto, Ontario M1S 1B1  
Phone: 416-299-0089  
Fax: 416-299-3255



## PACKING SLIP

VENDOR #	
DUNS #	242445328
TAX #	R105150197

73684

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www.tchweb.com

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All shipments FOB Scarborough, Ontario.  
Returns are subject to a 15% handling charge and must be authorized.  
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We have the right to charge collection and attorney's fees of 25% and  
interest of 2% per month (or 24% per annum) on all overdue accounts.

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Buffalo, New York 14206

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10552 King William Drive  
Dallas, TX 75220

1-800-465-6281  
www.tchweb.com



## **CERTIFICATE OF COMPLIANCE**

Date: JUNE 06, 2007

Customer Name DART AEROSPACE LTD.

Customer P.O. No. 3831 TCH Order No. 73684

Invoice No.: 90090 Date shipped: JUNE 06 2007

TCH Part No.: 555-C23 225

Item Description: BLK LEV LATCH RAISED TRIG w/LK

This is to certify that the items identified herein have been produced in accordance with applicable instructions and or specifications, drawings, approved samples and/or other descriptions set forth in the Purchase Order.

Signature:

A handwritten signature in black ink, appearing to read "John Shaffer". The signature is written over two lines: the first line contains "John" and the second line contains "Shaffer". The signature is somewhat stylized and cursive.

Title: